

Ship July 6th or sooner

Work Order ID 60002

June 22, 2010 2:34:36 PM

Page 1

Item ID: D4047-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Short Basket Lid Assembly

Start Date: 6/22/10 Start Qty: 1.00

Required Date: 7/02/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: 10-6-27 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4047

A

100

Weld per dwg A/R S.S. rod Batch: 1108775 0.00



Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4047
2- weld hinge and Mounting brackets as per dwg D4047
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4047
4- weld label plate

10-10-06-23

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

10-10-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run

Start

QC:

Date:

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Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

130

White Glass (Ref: 4.3.5.2) per QSI005 4.3-Steel

0.00

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Siolotlon

DBK 10-7-5

DBK 10-7-5

Pro.

f

W/O:		4047-011 WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-7-5	130 130	ADD SEQUENCE FOR PRESSURE WASH	BR	10-7-5				
			BR	10.07.06		1007-06	1007-06	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 7/02/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

135



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M114432 0.00

10/07/05

Memo

0.00

Mask label plate and Wing Walk and Spray Paint black as per Dwg D4047 and QSI 005 4.4

1 0

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10/07/05

150



Packaging

Packaging

Identify as per dwg & Stock Location: G-A 0.00

Memo

0.00

W/O 60000

10/07/05

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

100%
MF
10-7-6

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Picklist Print

June 22, 2010 2:34:35 PM

Page 1

Work Order ID: 60002

Parent Item: D4047-041

Parent Item Name: Short Basket Lid Assembly



Start Date: 6/22/10

Required Date: 7/02/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581



Mounting Bracket

Manufactured

No

100

Each

41.0000

2

2



PD 10.06.25

Location

Loc Qty

Loc Code

ST

15

59121

15

WA

26

46086

2

51745

2

57185

1

59265

21

100

Each

13.0000

3

3



PD 10.06.25

D4016-3



Hinge Half, Lid

Manufactured

No

Location

Loc Qty

Loc Code

ST116

1

58243

1

WA

12

58737

6

59744

6

100

Each

4.0000

1

1



PD 10.06.25

D4021-3



Data Plate

Manufactured

No

Location

Loc Qty

Loc Code

WA

4

56050

1

59054

3

PD 10.06.25

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June 22, 2010 2:34:35 PM

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Work Order ID: 60002

Parent Item: D4047-041











Parent Item Name: Short Basket Lid Assembly

Start Date: 6/22/10

Required Date: 7/02/10

Start Qty: 1.00

Required Qty: 1.00

D4046-7	Manufactured	No	100	Each	0.0000	1	1	
							B60025 -> (1)	PD 10.06.26
Mesh Lid								
D4047-043	Manufactured	No	100	Each	0.0000	2	2	
							B60026 -> (2)	PD 10.06.25
Rib Assembly								
D4047-1	Manufactured	No	100	Each	0.0000	2	2	
							B60027 -> (2)	PD 10.06.25
Rib								
D4047-5	Manufactured	No	100	Each	0.0000	2	2	
							B60028 -> (2)	PD 10.06.25
Rib								
D4047-7	Manufactured	No	100	Each	0.0000	6	6	
							B60029 -> (6)	PD 10.06.25
Rib								

June 22, 2010 2:34:35 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

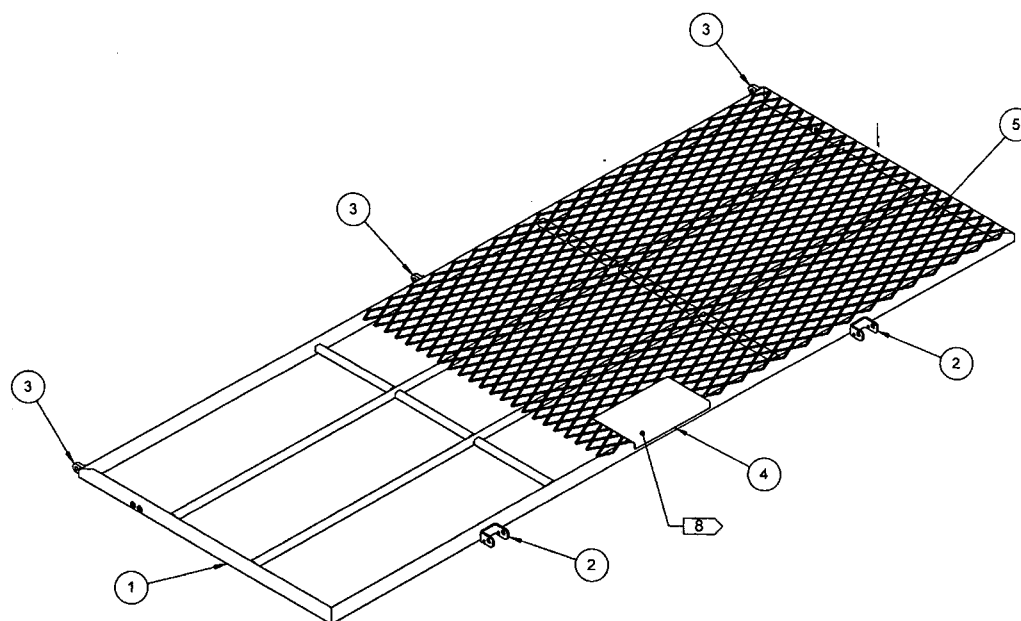
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4047-041	SHORT BASKET LID ASSY
1	1	D4047-101	LID FRAME ASSY
2	2	D2581	MOUNTING BRACKET
3	3	D4016-3	HINGE HALF, LID
4	1	D4021-3	LABEL PLATE
5	1	D4046-7	MESH



D4047-041 SHORT BASKET LID ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.17 lbs APROX
- 8) APPL BLACK ANTI-SKID PAINT TO TOP SURFACE OF MESH, EXCEPT ON D4021-3 LABEL PLATE PER DART QSI 005 4.4

SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60002
BD10-6-22

RELEASED
2010-02-16
MP

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>RF</i>		
MFG. APPR.	<i>RF</i>		
APPROVED	<i>RF</i>		
DE APPR.	<i>RF</i>		
DATE	10.01.29		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4047

REV. A
SHEET 1 OF 6

TITLE

SHORT BASKET LID ASSY

SCALE
NTS

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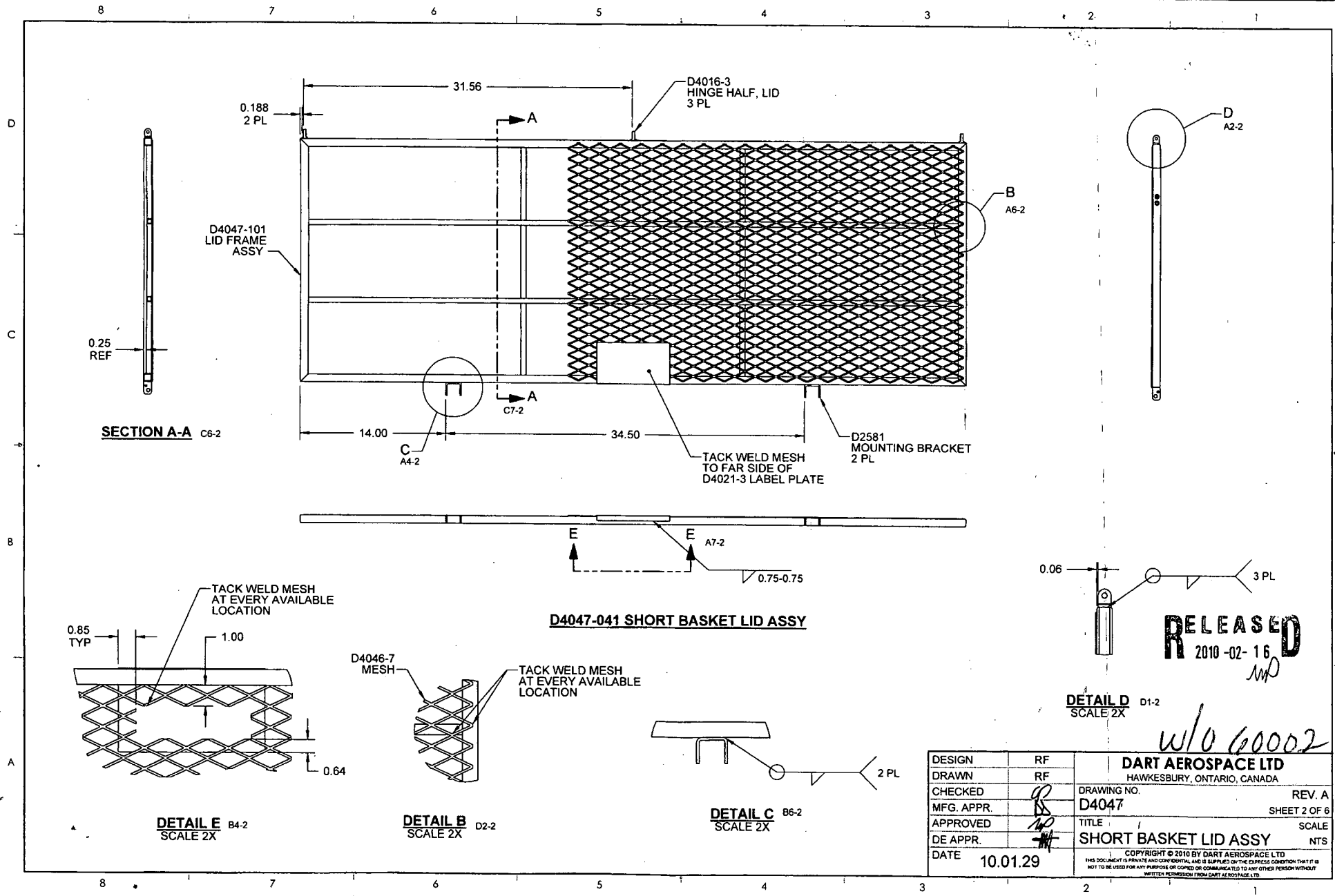
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DRAWN	RF		
CHECKED	RF	DRAWING NO. D4047	REV. A
MFG. APPR.	RF		SHEET 2 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHORT BASKET LID ASSY	NTS
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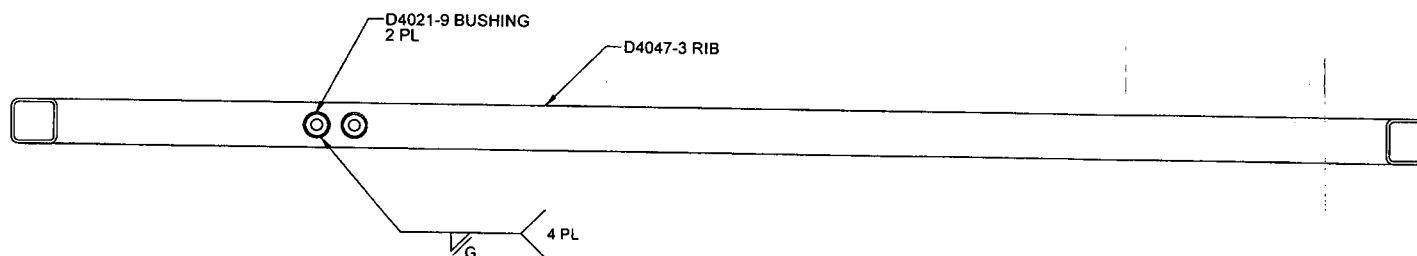
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4047-043	RIB ASSEMBLY
1	1	D4047-3	RIB
2	2	D4021-9	BUSHING



D4047-043 RIB ASSEMBLY

RELEASED
2010-02-16
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.88 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4047	SHEET 4 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SHORT BASKET LID ASSY	NTS
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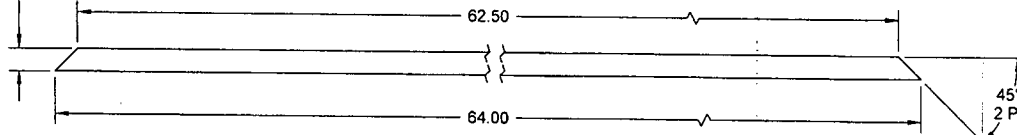
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

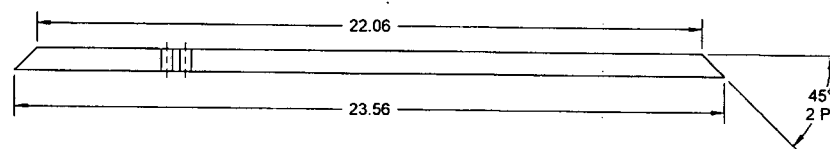
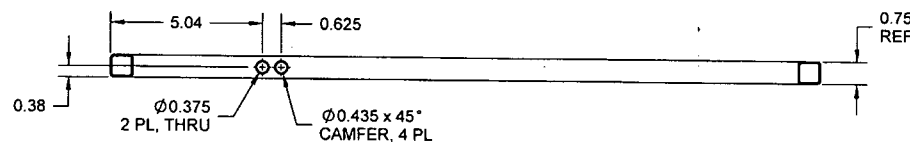
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NOTE: Date & initial all entries

0.75
REF



D4047-1 RIB



D4047-3 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4047-1: 2.63 lbs
D4047-3: 0.84 lbs

RELEASED
2010-02-16

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RS	DRAWING NO.	REV. A
MFG. APPR.	RS	D4047	SHEET 5 OF 6
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DE APPR.	RS	SHORT BASKET LID ASSY	NTS
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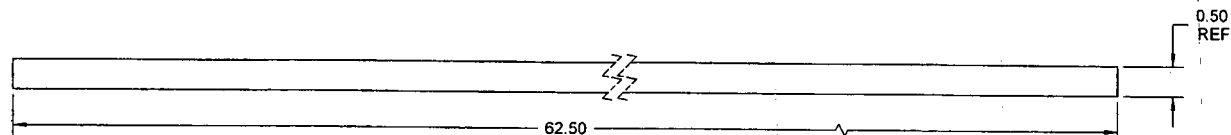
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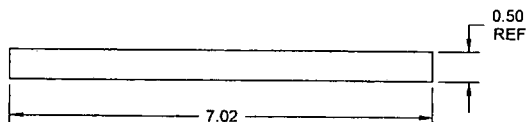
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D4047-5 RIB



D4047-7 RIB

RELEASED
2010-02-16
MP

W/6 60002

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4047-5: 1.44 lbs
D4047-7: 0.16 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>JS</i>	DRAWING NO. D4047	REV. A
MFG. APPR.	<i>JS</i>	SHEET 6 OF 6	
APPROVED	<i>JS</i>	TITLE	SCALE
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